

Shop Aeng 30

Date: Thursday, 2/9/2006 1:16:53 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SEAT FRAME ASSEMBLY		
Job Number	: 25789		Part Number	: D3016041		
Estimate Number	: 11122		Drawing Number	: D3016 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 2/9/2006 S.O. No. : N/A		Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 3/15/2006 Qty: 1 Um: Each		
Previous Run	: N/A					
Written By						
Checked & Approved By						
Comment	: Est. A 01.09.19 New issue EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
		Comment: Qty.: 6.8250 f(s)/Unit Total : 6.8250 f(s) 4130 Tube .750 OD x.049W Cut- AISI 4130N tube, Ø3/4" x 0.049" wall Batch: M100843 M 07/08/13
2.0	M4130NT1000W049	4130 Tube 1.0"D X .049"W
		Comment: Qty.: 2.6250 f(s)/Unit Total : 2.6250 f(s) 4130 Tube 1.0"D X .049"W M 07/08/13
3.0	M4130NT0500W049	4130 Tube .500 OD x.049W
		Comment: Qty.: 4.2000 f(s)/Unit Total : 4.2000 f(s) 4130 Tube .500 OD x.049W Cut- AISI 4130N tube, Ø1/2" x 0.049" wall Batch: M17109 M 07/08/13
4.0	D301617	Gusset
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Gusset Pick: Qty Part Number Description Batch 1 D3016-17 Gusset B22066 M 07/08/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
5.0	D301613	Bracket
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Bracket Pick: Qty Part Number Description Batch 1 D3016-13 Bracket <u>B16404</u>
6.0	D301615	Gusset
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Gusset Pick: Qty Part Number Description Batch 1 D3016-15 Gusset <u>B25762</u>
7.0	D30201	Fitting
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Fitting Pick: Qty Part Number Description Batch 2 D3020-1 Fitting <u>B22690</u>
8.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		Comment: LARGE FABRICATION RESOURCE 1 1-Cut all tubes as per Dwg D3016 2-Deburr 3-Weld as per Dwg D3016 A/R Steel Rod Batch: <u>M15684</u> 4-Transfer Drill Holes to D3016-041 From D3021-041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/08/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Weld as per Dwg D3016 using Welding Jig DT8597

① 07-08-15

11.0 POWDER COATING

POWDER COATING



M10484



(1X)

Comment: POWDER COATING

Install paint screws on fitting ends

Powder Coat Grey sandtex (Ref. 4.3.5.6) as per QSI 005

m-f

07/08/27

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mlo7/08/27

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mlo7/08/27

14.0 DC

DOCUMENT CONTROL



(1)

Comment: DOCUMENT CONTROL

Inspection Level 21

① 07/08/29

Job Completion



U 07-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

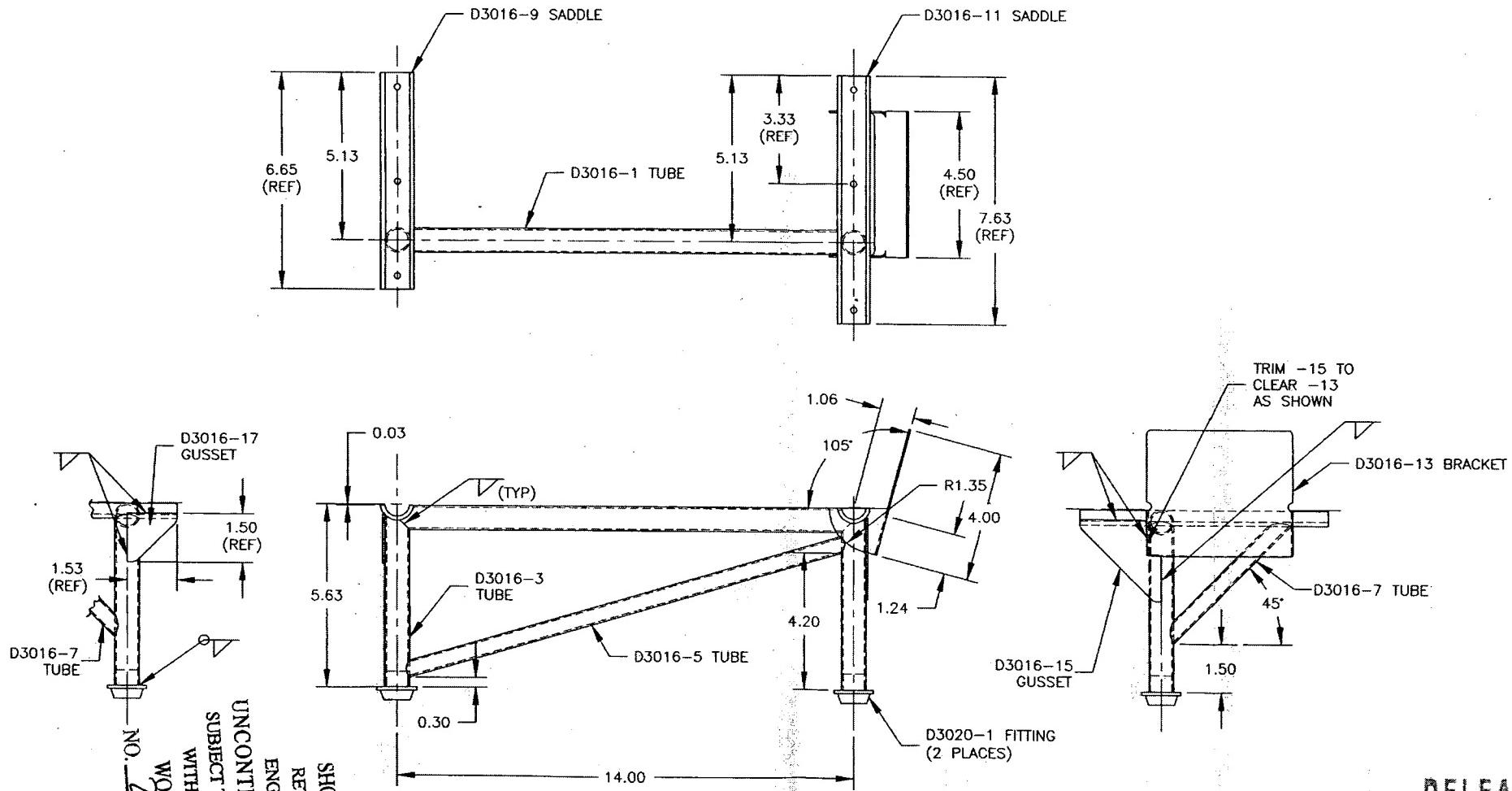
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D3016-041 SEAT FRAME ASSEMBLY



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ENGINEERING

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CP

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CP

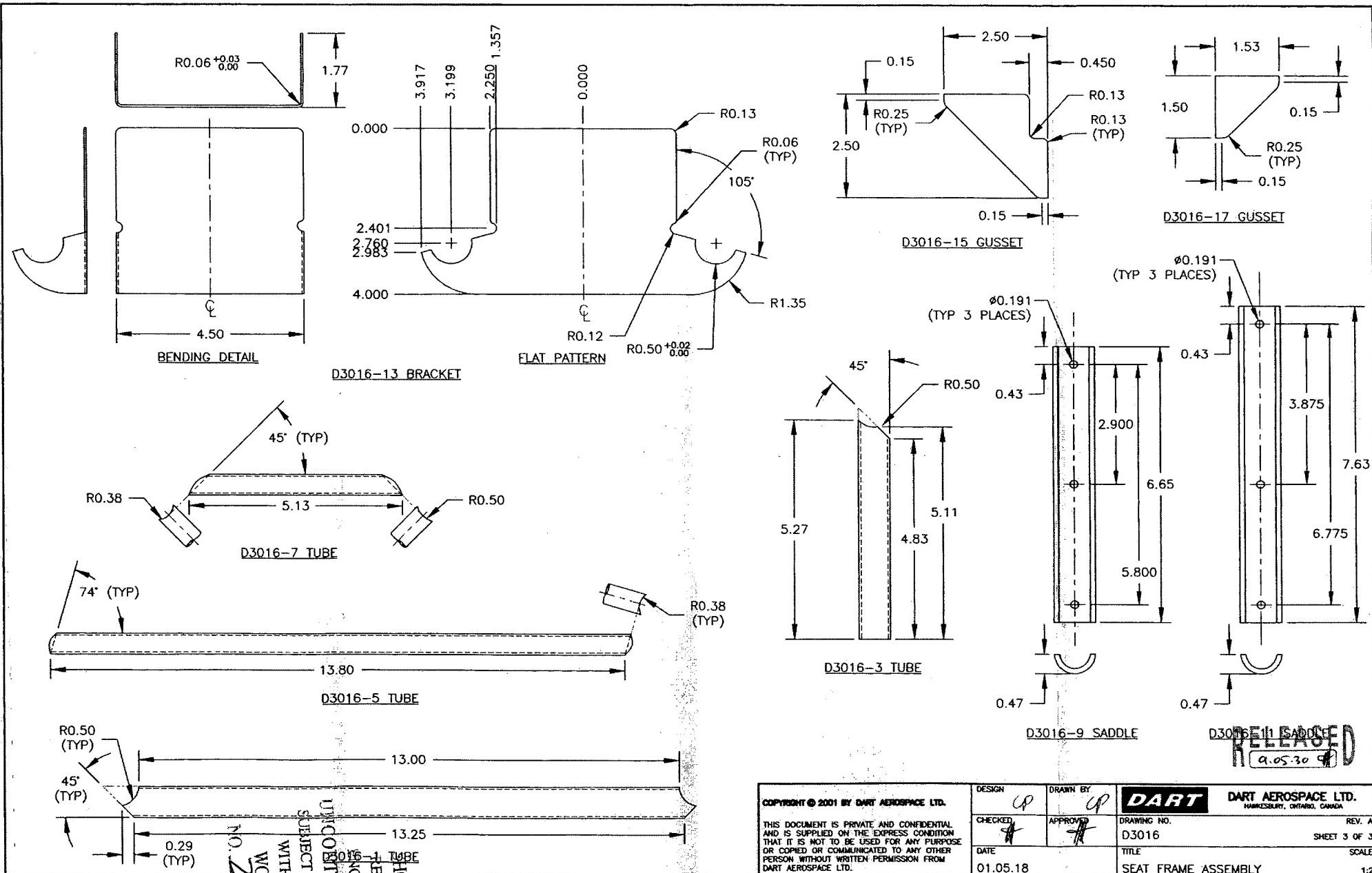
DART

DART AEROSPACE LTD.
HAWKSBURY, ONTARIO, CANADA

DRAWING NO. D3016 REV. A
SHEET 2 OF 3

DATE 01.05.18 TITLE SEAT FRAME ASSEMBLY SCALE 1:3

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01.05.30



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0.05.30 CP